

DART AEROSPACE LTD	Work Order:	21950
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Dwg: D3065 Rev. A1 A2	Qty:	60
RF 03.02.17 RF 03.02.28		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <i>Dwg. not required RF 02.11.04</i> (Minimum lots of 30)	<i>EP</i>	<i>04.11.23</i>	<i>60</i>
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>M1658d</i> Identify as D3065-1 <i>4.320" RF 02.11.29 4.320"</i>	<i>EP</i>	<i>05/01/14</i>	<i>60</i>
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.250" <i>4.320"</i>) <i>RF 02.11.29</i> Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>M16584</i> Identify as D3065-3	<i>EP</i>	<i>05/01/14</i>	<i>60</i>
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>M16584</i> Identify as D3065-7	<i>EP</i>	<i>05/01/14</i>	<i>60</i>
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch <i>M16241</i> Identify as D3065-5 (Note: make 2 legs per assembly)	<i>EP</i>	<i>05/01/14</i>	<i>60</i>
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch <i>M16241</i> Identify as D3066-1 (Note: make 2 spacers per assembly) <i>M16205</i> <i>M15021</i>	<i>EP</i>	<i>05/01/14</i>	<i>60</i>
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	<i>EP</i>	<i>05/01/17</i>	<i>60</i>
8	MV	Deburr to take measurement	<i>EP</i>	<i>05/01/17</i>	<i>60</i>
9	QC2	Inspect parts as they come off the CNC machine	<i>EP</i>	<i>05/01/17</i>	<i>60</i>
10	QC8	Second check	<i>EP</i>	<i>05/01/17</i>	<i>60</i>
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	<i>EP</i>	<i>05/01/17</i>	<i>60</i>
12	MV	Deburr to take measurement	<i>EP</i>	<i>05/01/17</i>	<i>60</i>
13	QC2	Inspect parts as they come off the CNC machine	<i>EP</i>	<i>05/01/17</i>	<i>60</i>
14	QC8	Second check	<i>EP</i>	<i>05/01/17</i>	<i>60</i>
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	<i>SD</i>	<i>05.01.17</i>	<i>60</i>
16	MV	Deburr to take measurement	<i>SD</i>	<i>05.01.17</i>	<i>60</i>
17	QC2	Inspect parts as they come off the CNC machine	<i>SD</i>	<i>05.01.17</i>	<i>60</i>
18	QC8	Second check	<i>EP</i>	<i>05/01/17</i>	<i>60</i>
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	<i>EP</i>	<i>05/01/17</i>	<i>120</i>

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05/01/07	#19	Step 19 shows up twice on the work order,	<i>[Signature]</i>	05.03.09	N/A	<i>[Signature]</i> 10/01/09	<i>[Signature]</i> 05.03.09	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	21950
Description: Hi - Step Leg Assembly RF 05.02.28	Part Number:	D3065-041
Dwg: D3065 Rev. A2 RF 05.02.17	Qty:	600
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																								
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	EP	05/01/17	120																								
20	MV	Deburr to take measurement	EP	05/01/17	120																								
21	QC2	Inspect parts as they come off the CNC machine	EP	05/01/17	120																								
22	QC8	Second check	ml	05/01/17	120																								
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	EP	05/01/17	60																								
24	MV	Deburr to take measurement	EP	05/01/17	60																								
25	QC2	Inspect parts as they come off the CNC machine	EP	05/01/17	60																								
26	QC8	Second check	ml	05/01/17	60																								
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack. (59)	ml	05-02-04	60/59																								
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065 59 59	J	05.02.09	59																								
29	QC5	Inspect work to Step 28	ML	05/02/09	59																								
30	FP	Chemical conversion coat as per QSI 005 4.1 RF 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	PD	05-02-22	59																								
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly. <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3065-1</td><td>Spacer</td><td>B 21950</td></tr><tr><td>1</td><td>D3065-3</td><td>Spacer</td><td>B 21950</td></tr><tr><td>2</td><td>D3065-5</td><td>Leg</td><td>B 21950</td></tr><tr><td>1</td><td>D3065-7</td><td>Spacer</td><td>B 21950</td></tr><tr><td>30</td><td>MS20470AD4-4</td><td>Rivet</td><td>M 15829</td></tr></table>	Qty	Part Number	Description	Batch	1	D3065-1	Spacer	B 21950	1	D3065-3	Spacer	B 21950	2	D3065-5	Leg	B 21950	1	D3065-7	Spacer	B 21950	30	MS20470AD4-4	Rivet	M 15829	SB	05/03/07	56
Qty	Part Number	Description	Batch																										
1	D3065-1	Spacer	B 21950																										
1	D3065-3	Spacer	B 21950																										
2	D3065-5	Leg	B 21950																										
1	D3065-7	Spacer	B 21950																										
30	MS20470AD4-4	Rivet	M 15829																										
32	QC5	Inspect work to Step 31	J	05.03.07	56																								
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly D3066-1 Spacer	SB	05/03/07	56																								
34	AC	Cost / part 36.09	SC	05.03.08	56																								
35	DC	Close W/O 56.07 Inspect Level 21	HA	05.03.09	56																								

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	SM	
B	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 21950		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-02-02	27	Found 1x D 3065-3 spacer with a splash in the hole	no perkins	Scrap it - No replace	ml 05-02-02	B 05-03-04	B perkins	As 05-03-04
05-02-08	28	1x D 3065-1 center hole punched crooked causing a crack.	B perkins	Destroy	J 05-02-07	B 05-02-08	B perkins	B 05-02-08

Part No: D3065-041 PAR #: _____ Fault Category: Manuf/Misc NCR: ☒ Yes ☐ No DQA: [Signature] Date: 05/03/10

NOTE: Date & initial all entries

QA: N/C Closed: [Signature] Date: 05.03.10

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 22, 2004
03:12 pm

Work Order No : 0021950
Project Name : D3065-041
Project For : WK452
Work Order Type : Main
Main WO Number :
House Part Number : D3065-041
Description : Step Leg Assembly
Manufactured : Yes
Amount Req'd : 60
Amount Done : 0
Start Date : 11-22-04
Est Finish Date : 12-20-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00